

**Work Order ID 71776**

Monday, July 11, 2011 2:35:53 PM

Page 1

Item ID: D350-604-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rear Locker Extender

Start Date: 7/11/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/2/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-07-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2273	D								
D350-604-041	A								
DSI9470	A								

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-604-041 CHG002

MF 11-9-19

110

0.00



Purchasing

PURCHASING

Memo

0.00

Purchasing

Issue P/O: 1445F  
Description: D350-604-041 Rear locker extender.  
Supplier: Delastek.  
Certification of Conformity and process sheet from Delastek is required.

4 x 2600-6 Camlock stud - Ship to Delastek B 117628

11-07-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 71776**

Monday, July 11, 2011 2:35:53 PM



Page 2

Item ID: D350-604-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rear Locker Extender

Start Date: 7/11/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/2/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

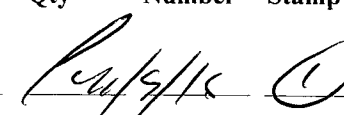
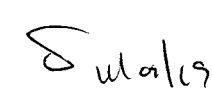
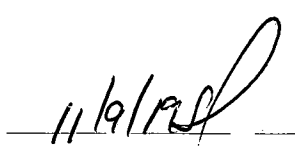
Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Packaging  Memo Ensure a copy of Certification of Conformity and process sheet from Delastek is attached.	0.00  0.00							
130  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo Check hole locations to template. DT 8824 Check process sheet and audit.	0.00  0.00							
140  Packaging Packaging	Pick Kit  Memo	0.00  0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 71776**

Monday, July 11, 2011 2:35:53 PM



Page 3

Item ID: D350-604-041

Accept



Setup Start



Revision ID:

Item Name: Rear Locker Extender

Stop



Start Date: 7/11/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/2/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

8/16/20

①

Quality Control

160

Packaging

0.00



Packaging

Memo

0.00

Identify and pack for shipping as per PPP D350-604-041

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

8/19/20

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

11/19/20

Quality Control

MF 11-0920

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, July 11, 2011 2:35:59 PM

Page 1

Work Order ID: 71776

Parent Item: D350-604-041

Parent Item Name: Rear Locker Extender





Start Date: 7/11/2011

Required Date: 9/2/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: Q ☐ 03.12.01 ☐ Reformat ☐ KJ/RF ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
2600-6  Camlock Stud		Purchased	No			110	Each	95.0000	4	4			
<div> <div>Location</div> <div>ST357</div> <div>117628</div> </div> <div> <div>Loc Qty</div> <div>95</div> <div>95</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D350-604-041P  Rear Locker Extender		Purchased	No			120	Each	0.0000	1	1			
<div> <div>Location</div> <div></div> <div></div> </div> <div> <div>Loc Qty</div> <div></div> <div></div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D2268  Decal		Manufactured	No			140	Each	14.0000	1				
<div> <div>Location</div> <div>ST010</div> <div></div> </div> <div> <div>Loc Qty</div> <div>14</div> <div></div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
<div> <div>Location</div> <div></div> <div>67420</div> </div> <div> <div>Loc Qty</div> <div></div> <div>2</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
<div> <div>Location</div> <div></div> <div>69592</div> </div> <div> <div>Loc Qty</div> <div></div> <div>12</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D2269  Decal		Manufactured	No			140	Each	11.0000	1				
<div> <div>Location</div> <div>ST010</div> <div></div> </div> <div> <div>Loc Qty</div> <div>11</div> <div></div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
<div> <div>Location</div> <div></div> <div>67421</div> </div> <div> <div>Loc Qty</div> <div></div> <div>11</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

117628

71776

6/4/11

11/9/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



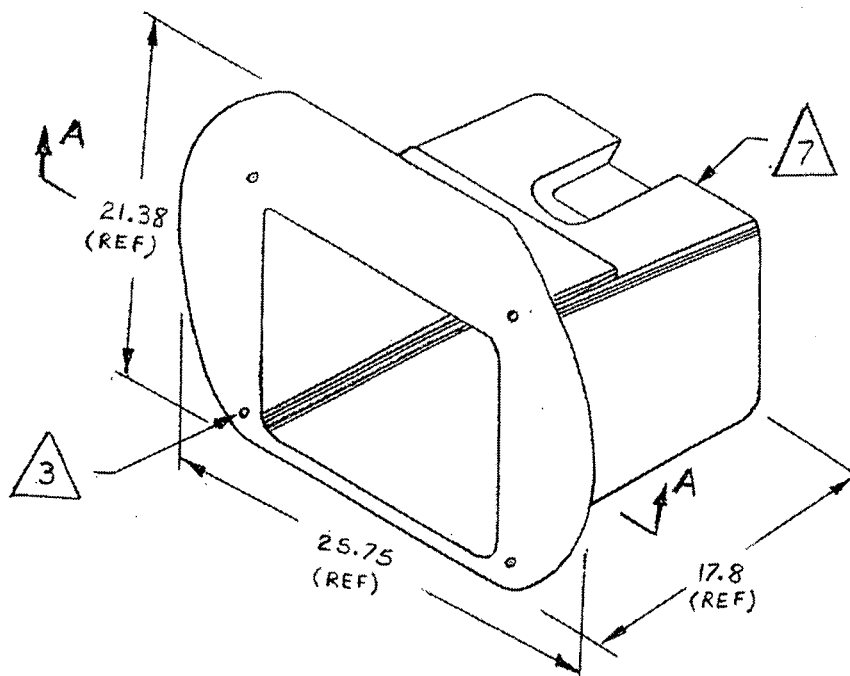


DESIGN JB	DRAWN BY <i>JP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2273	REV. D SHEET 1 OF 1
DATE 02.04.01		TITLE 350 REAR LOCKER EXTENDER	SCALE NTS
B	96.05.27	RE-DRAWN	
C	02.01.30	CLARIFY MATERIAL, LAYUP, AND TOOLING	
D	02.04.01	REMOVE EPOCAST, ADD SURFACE FINISH	

RELEASED  
02.04.03

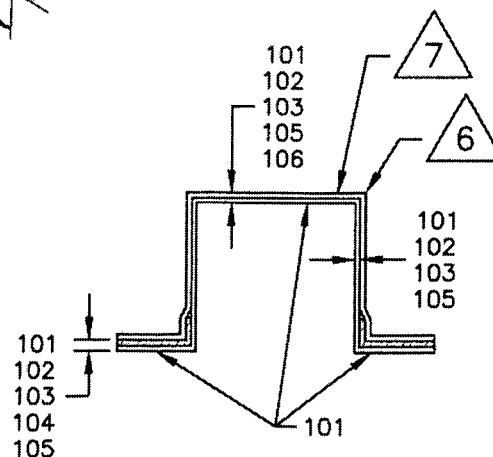
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 71776

*PH-07-4*



**NOTES:**

- 1) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING.
- 2) LAYUP USING DT8010 MOLD. WET LAYUP NO BAG/VACUUM.
- 3) TRIM & DRILL PER DT8020. OPEN HOLES TO  $\varnothing 0.257$  (4 PLACES).
- 4) MATERIALS:  
RESIN: DERAKANE 470-36/411/510A40  
FIBRE: 9oz = 9.7 oz 7781 WEAVE "S" GLASS  
18oz = 18.0 oz ROVING "E" GLASS.
- 5) CONSTRUCTION:  
101-WHITE GLOSS GELCOAT # GEL 944W005.  
102-9oz ALL OVER.  
103-18oz ALL OVER.  
104-18oz RE-INFORCE FRONT FLANGE EXTENDING 2" ON SIDES.  
105-9oz ALL OVER.  
106-PEEL PLY.
- 6) MATTE TO HOLD DOWN CORNERS AS REQUIRED.
- 7) FINISH THIS SURFACE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S.
- 8) ALL DIMENSIONS ARE IN INCHES.



SECTION A-A

Copyright © 1996 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Delastek inc.  
2699 5e avenue  
Local 14, Porte -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\* Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	40254
Customer #	DART US

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Ship to:

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
FEDEX Econo Collect		Origin		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
15/09/2011	12/07/2011	18179	Brigitte Golden		PO14458		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0003	Line #4 Rear Locker Extender D350-604-041P B71776 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D  <div>No. série B71776</div> <div>No. lot 34247</div> Jul 08/119			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department AQ-357



Date: Mercredi, 2011-07-06 14:17:41  
Utilisateur: marc dubé

## Feuille de Procédé

Client : DART US DART AEROSPACE LTD  
Numéro Job : 34247  
Numéro Soumission : 3482  
Numéro B.A. :  
Cette fois : 2011-07-06 No. B.V. :  
Prsht Rev. : NC  
Prem. fois : - - Type :  
Job précédente : 34246

Nom Dessin : REAR LOCKER EXTENDER  
Numéro Article : DKC134-0003  
Numéro Dessin : D350-604-041 & D2273  
Projet Numéro : DK-362  
Révision dessin : A & D  
Matériel : Derakane 470-36/411/510  
Date Due : 2011-07-13 Qté: 1 UdM: UNITE

Écrit par :  
Vérifié & Approuvé par :  
Commentaires : N° de pièce Laminée Dart Aerospace: D2273  
N° de pièce Assemblage Dart Aerospace: D350 604 041



B 71776

Process Sheet Rév.: 03 Modifier la séq. 6 Prep-general.

## Produit additionnel

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

1.0

PRÉPARATION

Préparation du moule



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire la préparation du moule DKO-0250 selon IG 0009.

Date: Sceau:

2.0

AMB0350

Gel Coat Blanc N° Gel 944W005

Commentaire Qty.: 1.580 UNITE(s)/Unit Total : 1.580 UNITE(s)

Gel Coat Blanc N° Gel 944W005

N° de Lot:

1-31894-2

3.0

AMB0286

Catalyst N° DDM-9

Commentaire Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s)

Catalyst N° DDM-9

N° de Lot:

1-27829-1

4.0

AC0747

Acetone

Commentaire Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)

5.0

PREP-GENERAL

Préparation du matériel



Commentaire Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

Tailler le matériel selon les dimensions requises à l'aide de gabarit de trimage prévus à cet effet.

Date: 11-08-11 Sceau:



Date: Mercredi, 2011-07-06 14:17:41  
Utilisateur: . marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 34247

Nom Dessin: REAR LOCKER EXTENDER  
Numéro Article: DKC134-0003

Numéro Job:



# Séq.: Machine ou Opération: Description :

6.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire la préparation du Gel coat selon IF134-0003 .

Date: 30/08/11 Sceau:

7.0 GEL COAT Application du Gel Coat



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

Appliquer le gel coat selon IF 134-0003(réf. IG0019).

Note: Le gel coat ne doit contenir aucun "airdry" ni aucune cire. Et le temp de séchage est important afin d'éviter d'avoir des défauts de surface, et afin d'éviter que le tissu ne vienne marquer au travers du Gel Coat ainsi que d'éviter d'avoir un rétrécissement.

Quantité: 1 Date: 30/08/11 Sceau:

8.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.680 LITRE(s)/Unit Total: 1.680 LITRE(s)

Résine (411B7530) 411-350 promo. 75min

N° de Lot: 1-31894-1

9.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0070 GALLON(s)/Unit Total: 0.0070 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-27829-1

10.0 AMB0214 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentair Qty.: 4.6 VERGE(s)/Unit Total: 4.6 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: ~~1-28778-1~~ 1-31000-2

11.0 AMB0213 WR1850 Roving 18oz. x 50"

Commentair Qty.: 1.140 KILOGRAMME(s)/Unit Total: 1.140 KILOGRAMME(s)

WR1850 Roving 18oz. x 50"

N° de Lot: 1-28778-1

12.0 LAMINAGE Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 3.5000Hrs Total Run : 3.5000Hrs

Selon IF 134-0003. S'assurer de ne pas trapper d'air entre les rangs.

Inscrire les informations suivantes:

Humidité: 31% Température: 76.8°F Heure: 1:30

Quantité: 1 Date: 31/08/11 Sceau:

Date: Mercredi, 2011-07-06 14:17:42  
Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 34247

Nom Dessin: REAR LOCKER EXTENDER  
Numéro Article: DKC134-0003

Numéro Job:




# Séq.: Machine ou Opération: Description :

20.0 PRIMER Application primer



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Appliquer le primer selon IG 0008.

Quantité: 1 Date: 14 Sept 11 Sceau:  N° fiche de Mélange: N/A

21.0 AAC1607 Camlock Stud 2600-4 (or Monadnock 1126000-4)

Commentair Qty.: 4 UNITE(s)/Unit Total : 4 UNITE(s)  
Camlock Stud 2600-4 (or Monadnock 1126000-4)

N° de Lot: 1-31768-1

22.0 AAC0682 Washer 2600-LW (1127700)

Commentair Qty.: 4 UNITE(s)/Unit Total : 4 UNITE(s)  
Washer 2600-LW (1127700)

N° de Lot: 1-6687-1

23.0 ASSEMBLAGE Assemblage mécanique




Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'assemblage selon IF134-0004.

Démasker la pièce.

Assembler les "Studs" selon IG 0037.

Quantité: 1 Date: 14 Sept 11 Sceau: 

24.0 IDENTIFICATION Identification à encre indélébile




Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'identification de la pièce selon IF134-0005.

N° de pièce Cleint: D350-604-041

N° de Job: 34247

N° de Fabrication: 15-09-11

Quantité: 1 Date: 15-09-11 Sceau: 

25.0 INSPEC FINAL Inspection finale



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin.

Date: Mercredi, 2011-07-06 14:17:42

Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: REAR LOCKER EXTENDER

Numéro Job: 34247

Numéro Article: DKC134-0003

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

Quantité: 1

Date: 15 SEP. 2011

Sceau:



26.0

EMBALLAGE

Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'emballage selon IG 0057.

Quantité: 1

Date: 15/9/11

Sceau:



Job 15 sept 11  
lab 34247